

# Work Order ID 90647

\*90647\*

Page 1

September-21-12 11:30:42 AM

Item ID: K10112 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle, Skidtube 206  
 Start Date: 9/21/12 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 10/19/12 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-09-21 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10112	C								
100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-112 CHG007 FOR D206-642-114 CHG002	K10112 CHG003							
110	Pick Kit	0.00							
*110*									
Packaging	Memo	0.00							
Packaging									

15  
11-02

6x MLJ 12-10-5  
 ⑥

6 12/10/09 23

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

  

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

# Picklist Print

September-21-12 11:30:41 AM

Page 1

WorkOrder ID: 90647  
Parent Item: K10112  
Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12 Required Date: 10/19/12  
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F 11.09.23 PER REV.B DD  
VERF:EC IPP REV:G 11.11.14 AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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**D206-651-041**  
206A/B GHW

Manufactured No

110 Each 14.0000

0 5x 'B91164 SP.

Location	Loc Qty	Loc Code
FG	2	
79558	2	
FG125	12	
79558	1	
83042	6	
87723	4	
88595	1	

1/ SMB 6x

**D2652**  
Bushing

Manufactured No

110 Each 726.0000

0 96 20

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST014	682	
73836	25	
88780	657	

SMB 6x

**D3419-1**  
Ring

Manufactured No

110 Each 43.0000

0 6 10 12/10/09

Location	Loc Qty	Loc Code
ST420	8	
86562	8	
ST421	10	
88025	10	
ST464	25	
80224	4	
83307	3	
83867	18	

SMB 6x

88780

83867

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 2

Work Order ID: 90647

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

**D2661-2**

Manufactured No

110 Each 28.0000

12

Saddle, RH Fwd Aft Out 206

## Location

## Loc Qty

## Loc Code

FG 2  
80990 2  
MEZZ 6  
10015 1  
10016 1  
10476 3  
9913 1  
ST434 20  
80990 20

80990

**D2662-2**

Manufactured No

110 Each 27.0000

12

Saddle, RH In 206

## Location

## Loc Qty

## Loc Code

FG 2  
80992 2  
Mezz 2  
11028 4  
9042 3  
9043 2  
ST434 16  
80992 14  
83491 2

1x80992

**D2712**

Manufactured No

110 Each 820.0000

60

Set Screw

## Location

## Loc Qty

## Loc Code

FG 50  
29962 50  
ST016 520  
84433 220  
86911 300  
ST019 250  
87644 250

11x 84433

49x 86911

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Shop Packet Print

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NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
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Unapproved <input type="checkbox"/>											

  

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Picklist Print

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Work Order ID: 90647

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

**D2884**

Saddle Spacer

Manufactured No

110 Each 41.0000

2 8x90494<sup>12</sup> ✓ 20

Sms 6x

Location

Loc Qty

Loc Code

FG	10	
29453	10	
ST020	31	
76751	31	

4x76751

**D2885**

Saddle Spacer

Manufactured No

110 Each 32.0000

2 90493<sup>12</sup> ✓ 20

50

Sms 6x

Location

Loc Qty

Loc Code

FG	10	
29199	10	
ST020	22	
76752	22	

**A341A**

Bolt

Purchased No

110 Each 253.0000

8 48

13

50

Sms 6x

Location

Loc Qty

Loc Code

FG	20	
122416	20	
ST353	33	
122416	33	
ST354	200	
121243	200	

121243

**A4G5A**

BOLT

Purchased No

110 Each 339.0000

0 6

20 12/10/09

50

Sms 6x

Location

Loc Qty

Loc Code

ST355	339	
112243	129	
119017	12	
122599	198	

122599

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Shop Packet Print

Page 3

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
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# Picklist Print

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Page 4

Work Order ID: 90647

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

ANS-6A

Bolt

Purchased

No

110

Each

1,313.0000

12

72

✓ 70

SD

## Location

## Loc Qty

## Loc Code

ST355

800

122808

600

123021

200

ST356

513

121243

500

122151

13

122808

Smb 6x

ANS-10A

Bolt

Purchased

No

110

Each

337.0000

4

24

✓ 70

SD

## Location

## Loc Qty

## Loc Code

ST337

237

118191

80

121243

100

122151

57

ST362

100

122800

100

19x121243

5x121151

Smb 6x

ANS-01A

Bolt

Purchased

No

110

Each

314.0000

4

24

✓ 70

SD

## Location

## Loc Qty

## Loc Code

ST337

314

118191

13

119512

301

119512

Smb 6x

ANS-4A

Bolt

Purchased

No

110

Each

57.0000

2

12

✓ 70

SD

## Location

## Loc Qty

## Loc Code

ST340

30

122416

30

ST343

7

119127

7

st510

20

119036

20

122416

Smb 6x

September-21-12 11:30:41 AM

Shop Packet Print

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NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved <input type="checkbox"/>																											

FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other		

# Picklist Print

September-21-12 11:30:41 AM

Page 5

Work Order ID: 90647  
 Parent Item: K10112  
 Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

**NAS1149D0363J**

Purchased No

110 Each 4,172.0000 **8** 48

Washer

## Location

## Loc Qty

## Loc Code

ST297 3958  
 122378 3958  
 ST298 214  
 116025 1  
 117601 61  
 119537 33  
 120142 13  
 120308 17  
 121243 17  
 121524 72

122378

SMB

**NAS1149D0463J**

Purchased No

110 Each 4,741.0000 **24** 144

Washer

## Location

## Loc Qty

## Loc Code

298 232  
 122441 232  
 ST298 4471  
 104746 1  
 116805 0  
 119073 20  
 122452 4450  
 ST299 38  
 121912 38

122452

SMB

**NAS1149D0563J**

Purchased No

110 Each 4,164.0000 **8** 48

Washer

## Location

## Loc Qty

## Loc Code

ST298 4164  
 121255 1164  
 122452 3000

121255

SMB

September-21-12 11:30:42 AM

Shop Packet Print

Page 5

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

  

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

# Picklist Print

September-21-12 11:30:42 AM

Page 6

Work Order ID: 90647

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

**WAS149D0663J**

Washer

Purchased

No

110

Each

858.0000

24

## Location

## Loc Qty

## Loc Code

ST294

858

123021

858

**MS210421B**

Nut

Purchased

No

110

Each

2,556.0000

## Location

## Loc Qty

## Loc Code

316

719

122452

719

ST300

574

117885

32

119017

404

119075

138

ST317

1263

122141

1263

**MS210421L4**

Nut

Purchased

No

110

Each

6,178.0000

## Location

## Loc Qty

## Loc Code

314

3147

122452

3147

FP001

4

8182

4

ST300

27

119017

20

121444

7

ST314

3000

123021

3000

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Page 6

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

**FAULT CATEGORY**

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	--

# Picklist Print

September-21-12 11:30:42 AM

Page 7

Work Order ID: 90647

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 9/21/12

Required Date: 10/19/12

Start Qty: 6.00

Required Qty: 6.00

MS2104216  
Nut

Purchased

No

110

Each

727.0000

12

✓ 20



Location

Loc Qty

Loc Code

314

448

122441

448

122441

ST300

279

117677

25

118384

3

118927

48

119075

4

120308

199

Purchased

No

110

Each

657.0000

6

✓ 20

12/10/09



Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

656

117735

17

119097

639

119097

NAS1149C0463R  
Washer

Purchased

No

110

Each

657.0000

6

✓ 20

12/10/09



Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

656

117735

17

119097

639

119097

September-21-12 11:30:42 AM

Shop Packet Print

Page 7

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	<b>Date</b>	<b>Step</b>	<b>Qty</b>	<b>Description of work order update or Non-conformance</b>	<b>Initial Chief Eng</b>	<b>Action Description</b>	<b>Sign &amp; Date</b>	<b>Verification</b>	<b>QC Inspector</b>		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

## PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

### 4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES) 32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

### IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

### WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

NO. 90647 INC 5  
12-09-21  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
RETURN TO  
ENGINEERING  
SHOP COPY

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BOLT SUBSTITUTION	NTS
DATE	11.11.02	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**DAS**  
15  
12/1/02

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
<del>1</del>	<del>D206-651-041</del>	<del>1</del>	<del>1</del>	<del>1</del>
2	D2652	16	16	16
<del>3</del>	<del>D3413-1</del>	<del>1</del>	<del>1</del>	<del>1</del>
<del>4</del>	<del>D2661-2</del>	<del>2</del>	<del>2</del>	<del>2</del>
<del>5</del>	<del>D2662-2</del>	<del>2</del>	<del>2</del>	<del>2</del>
<del>6</del>	<del>D2712</del>	<del>10</del>	<del>10</del>	<del>10</del>
<del>7</del>	<del>D2884</del>	<del>2</del>	<del>2</del>	<del>2</del>
<del>8</del>	<del>D2885</del>	<del>2</del>	<del>2</del>	<del>2</del>
<del>9</del>	<del>AN3-41A</del>	<del>8</del>	<del>8</del>	<del>8</del>
<del>10</del>	<del>AN4C5A</del>	<del>1</del>	<del>1</del>	<del>1</del>
<del>11</del>	<del>AN4-6A</del>	<del>12</del>	<del>12</del>	<del>12</del>
12	AN5-7A		8	
<del>13</del>	<del>AN5-10A</del>	<del>4</del>		4
<del>14</del>	<del>AN5-11A</del>	<del>4</del>		4
<del>15</del>	<del>AN6-44A</del>	<del>2</del>	2	2
<del>16</del>	<del>NAS1149D0363J</del>	<del>8</del>	8	8
<del>17</del>	<del>NAS1149D0463J</del>	<del>24</del>	24	24
<del>18</del>	<del>NAS1149D0563J</del>	<del>8</del>	8	8
<del>19</del>	<del>NAS1149D0663J</del>	<del>4</del>	4	4
<del>20</del>	<del>MS21042-3 (OR L3)</del>	<del>8</del>	8	8
<del>21</del>	<del>MS21042-4 (OR L4)</del>	<del>12</del>	12	12
<del>22</del>	<del>MS21042-6 (OR L6)</del>	<del>2</del>	2	2
<del>23</del>	<del>NAS1149C0463R</del>	<del>1</del>	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>E</i>	K10112	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>TH</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

90647

